

# APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04489

SHEET 1 OF 1

DWG NO. 644,4100

REV: F

PREPARED  
BY:

J. BECKER

DATE: 04/08/14

EFFECT ON DWG  
☐ INC. ☒ UNINC.

DWG TITLE: PIVOT STEP ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):  
A-ADD C-CREATE  
R-REVISE D-DELETE

REASON: UPDATE NOTE 4, FINISH SPECIFICATION.

## NOTES:

1. IDENTIFY ALL PARTS IN ACCORDANCE WITH MPP-120

2. MATERIAL: 2024-T3 ALUMINUM

3. MATERIAL: 6061-T6 ALUMINUM

4. FINISH IAW MPP-172 SECTION 2.1, SECTION 3.1, SECTION 4.1, SECTION 5.2.

5. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH,  
CUT ID HOLE USING 1/4" GASKET PUNCH

6. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH,  
CUT ID HOLE USING 5/16" GASKET PUNCH

7. DIMENSION VALUE HAS FINISH COATING OF 6-10 MIL (.006-.010) TAKEN INTO  
CONSIDERATION

8. ADD ADDITIONAL WASHER UNDERNEATH CASTLE NUTS IF NECESSARY.

9. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK.

## SHEET 1, NOTES IS:

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM

CHANGE CATEGORY  
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED  
☐ YES ☒ NO

# APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04286

SHEET 1 OF 1

DWG NO. 644.4100

REV: F

PREPARED BY J. SOTO

DATE: 12/04/2013

EFFECT ON DWG  
☐ INC. ☒ UNINC.

DWG TITLE: PIVOT STEP ASSY

APPROVED BY: ENGR *[Signature]*

MFG *[Signature]*

QC

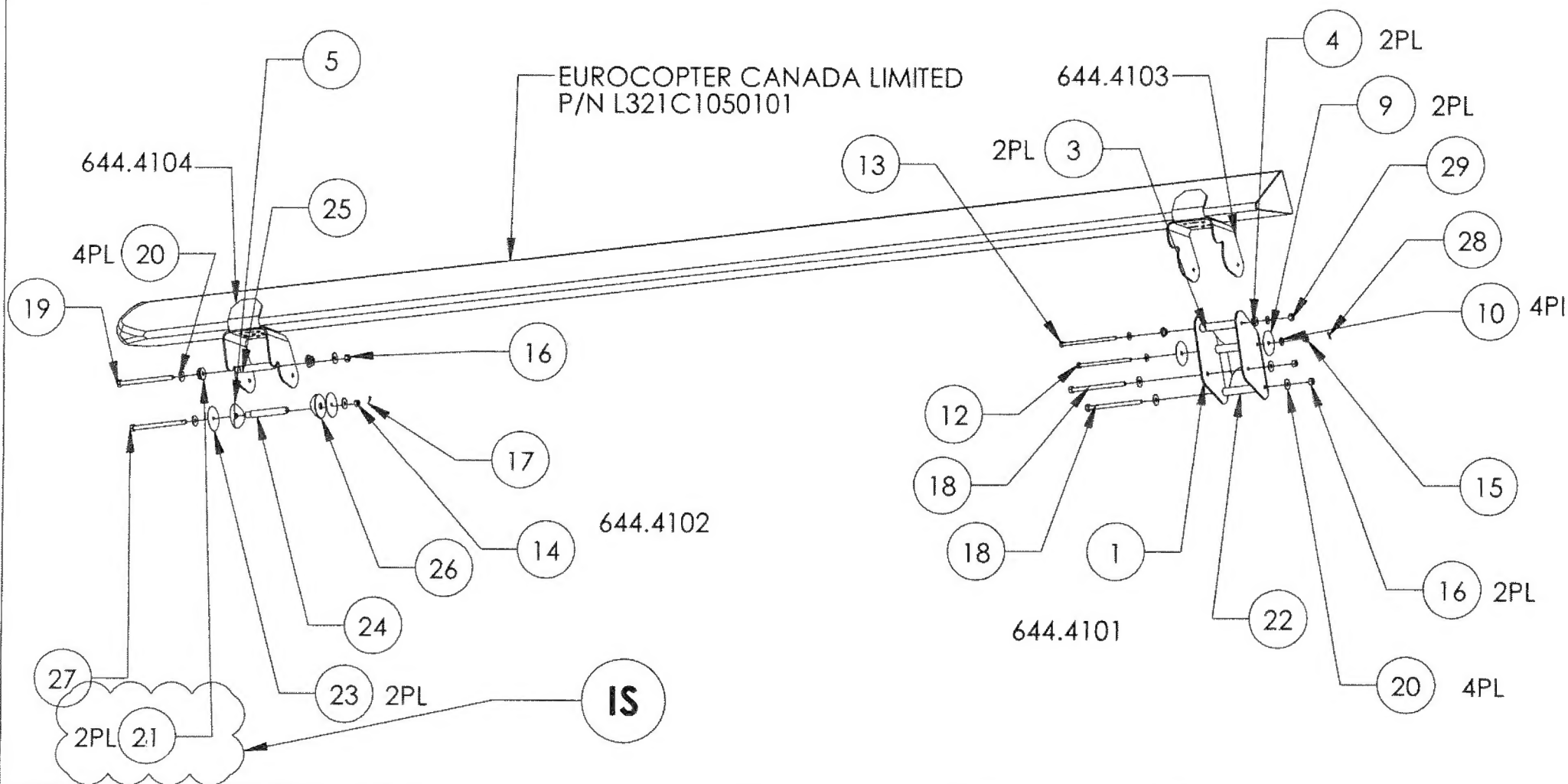
EFF. NEXT ORDER

TRANSACTION CODES (TC):  
 A-ADD  
 R-REVISE  
 C-CREATE  
 D-DELETE

REASON: REVISED F/N CALL OUT FROM 22 TO 21

ECR: 13-151

## SHEET 1, ZONE D1 IS:



DOCUMENTS EFFECTED:

☐ MDL 
 ☐ INSTALL INSTRUCTIONS 
 ☐ ICA 
 ☐ FMS 
 ☐ BOM

CHANGE CATEGORY

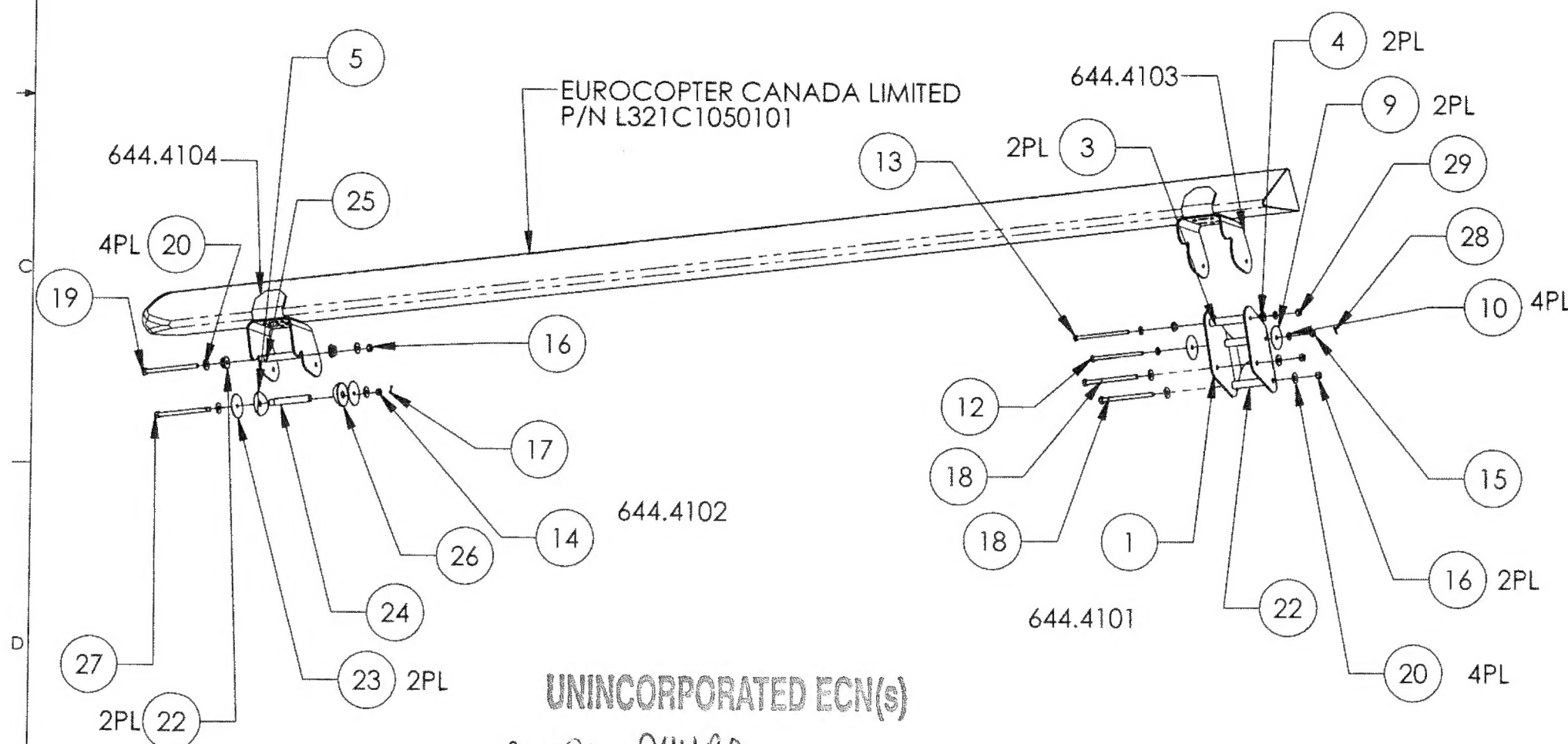
☐ MAJOR 
 ☒ MINOR

DER REVIEW REQUIRED

☐ YES 
 ☒ NO

NOTES:






- |   |  |          |    |
|---|--|----------|----|
| B | INCORPORATED ECN 01370, 01418, 01796, & 01838. | 05-21-07 | P. |
| C | INCORPORATED ECN 01908, 02326, 03022           | 12-14-10 | P. |
| D | INCORPORATED ECN 03111, 03113, 03208, & 03740. | 12-10-12 | P. |
| E | INCORPORATED ECN 03941                         | 06-19-13 | P. |
| F | INCORPORATED ECN 04006                         | 7-29-13  | P. |



UNINCORPORATED ECN(S)

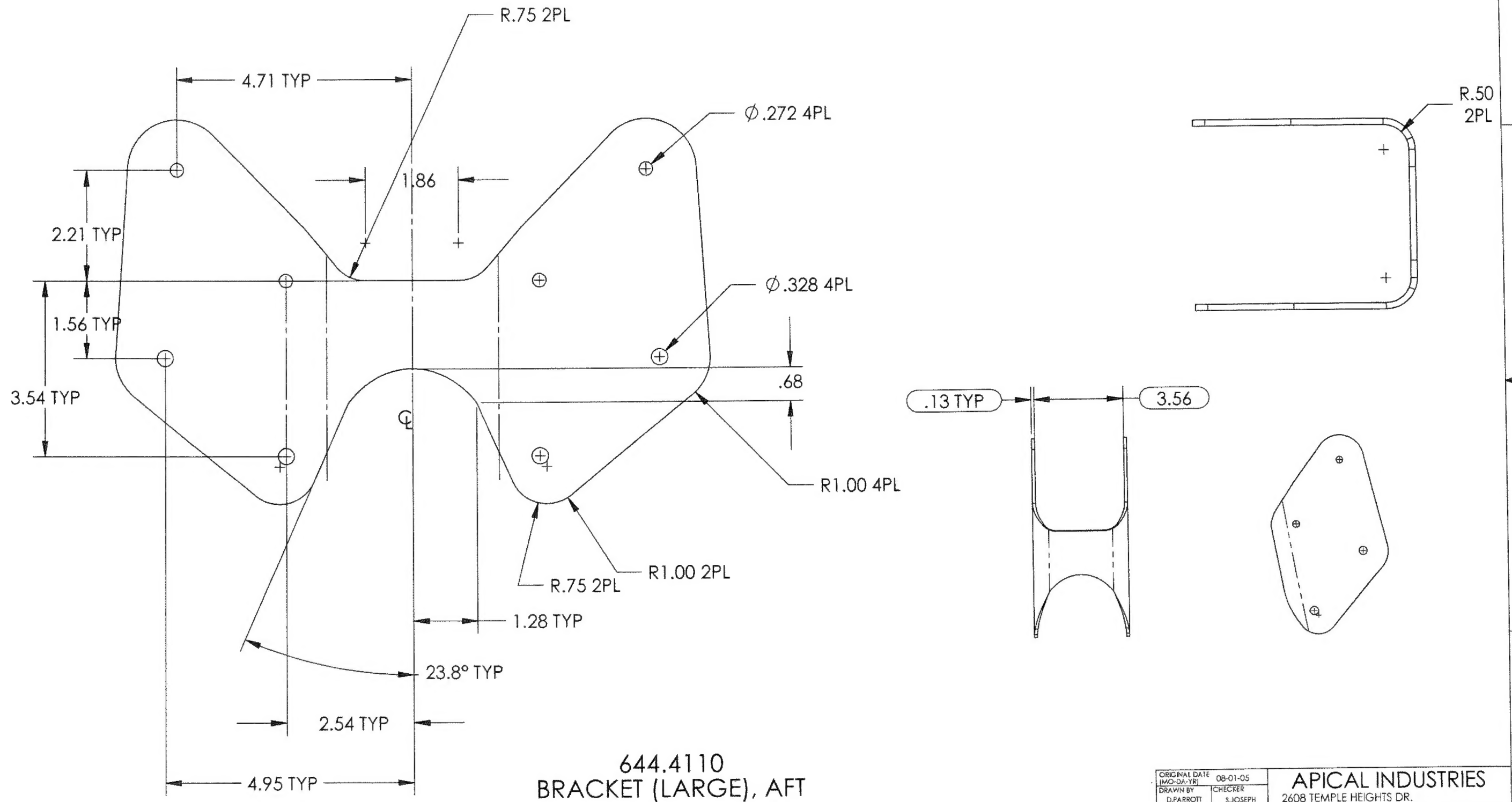
04286, 04489

REVIEWS			
REV.	DESCRIPTION	DATE	APPROVE
A	INCORPORATED ECN 01310, 01322, 01332, & 01357.	11-22-05	S. JOSEPH
B	INCORPORATED ECN 01370, 01418, 01756, & 01858.	05-21-07	P. BRAVCO
C	INCORPORATED ECN 01908, 02326, 03022	12-14-10	P. BRAVCO
D	INCORPORATED ECN 03111, 03113, 03208, & 03740.	12-10-12	P. BRAVCO
E	INCORPORATED ECN 03941	06-19-13	P. BRAVCO
F	INCORPORATED ECN 04006	7-29-13	P. BRAVCO

		1	29	601.3273	LOCKNUT FULL	MS21044N4	
		1	28	601.2640	COTTER PIN	MS24665-132	
		1	27	601.2328	BOLT, HEX	AN5-45	
		1	26	644.4124	WASHER, PIVOT		
		1	25	644.4123	FWD CROSSTUBE BUSHING		
		1	24	644.4122	FWD CROSSTUBE BUSHING		
		2	23	644.4121	WASHER, NYLON		
		1	22	644.4120	SPACER, CROSS-TUBE		
		2	21	644.4119	SPACER, FWD STOP		
		4	4	20	601.2110	WASHER, FLAT THICK	NAS1149C 0563R
		1	19	601.2250	BOLT, HEX	AN5-50	
		2	18	601.2249	BOLT, HEX	AN5-43A	
		1	17	601.3315	COTTER PIN	MS24665-210	
		1	2	16	601.3272	LOCKNUT FULL	MS21044N5
		1	15	601.1435	NUT, HEX CASTLE FULL	AN310-4	
		1	14	601.3270	NUT, HEX CASTLE FULL	AN310-5	
		1	13	601.3407	BOLT, HEX	AN4-47A	
		1	12	601.2434	BOLT, HEX	AN4-45	
6	3		11	601.2326	RIVET, COUNTERSUNK	MS20426AD5-B	
			4	10	601.0863	WASHER, THICK	NAS1149C 0463R
			2	9	644.4118	WASHER, NYLON	
1			8	644.4117	BRACKET, FWD PIVOT		
1			7	644.4116	BRACKET (SMALL), FWD		
	1		6	644.4115	BRACKET (SMALL), AFT		
		1	5	644.4114	WASHER, PIVOT		
		2	4	644.4113	SPACER, STOP		
		2	3	644.4112	SPACER		
	1		2	644.4111	BRACKET, AFT PIVOT		
		1	1	644.4110	BRACKET (LARGE), AFT		
		1		644.4104	FWD BRACKET ASSY		
			1	644.4103	AFT BRACKET ASSY		
				644.4102	PIVOT STEP ASSY		
				644.4101	PIVOT STEP ASSY		

4104410341024101	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY		PARTS LIST			
NEXT ASSY (\$)  644.1800		ORIGINAL DATE (MO-DA-YR)	08-01-05		
		DRAWN BY	CHECKER		
		D.PARROTT	S.JOSEPH		
		DRAWING APPROVAL			
		S.JOSEPH	08-29-05		
		CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SIZE		CAGE CODE	DWG. NO.
		B	07M26	644.4100	
SCALE: NONE				SHEET 1 OF 1	

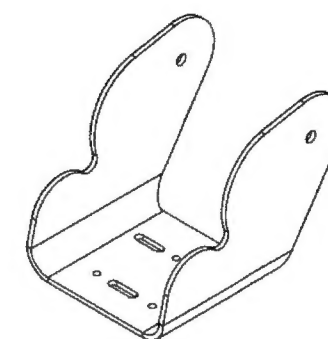
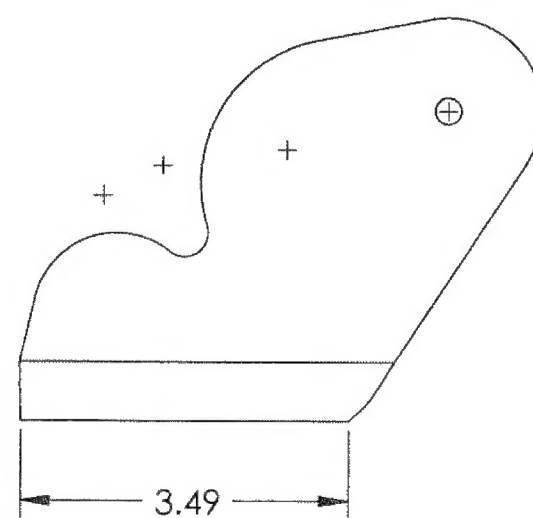
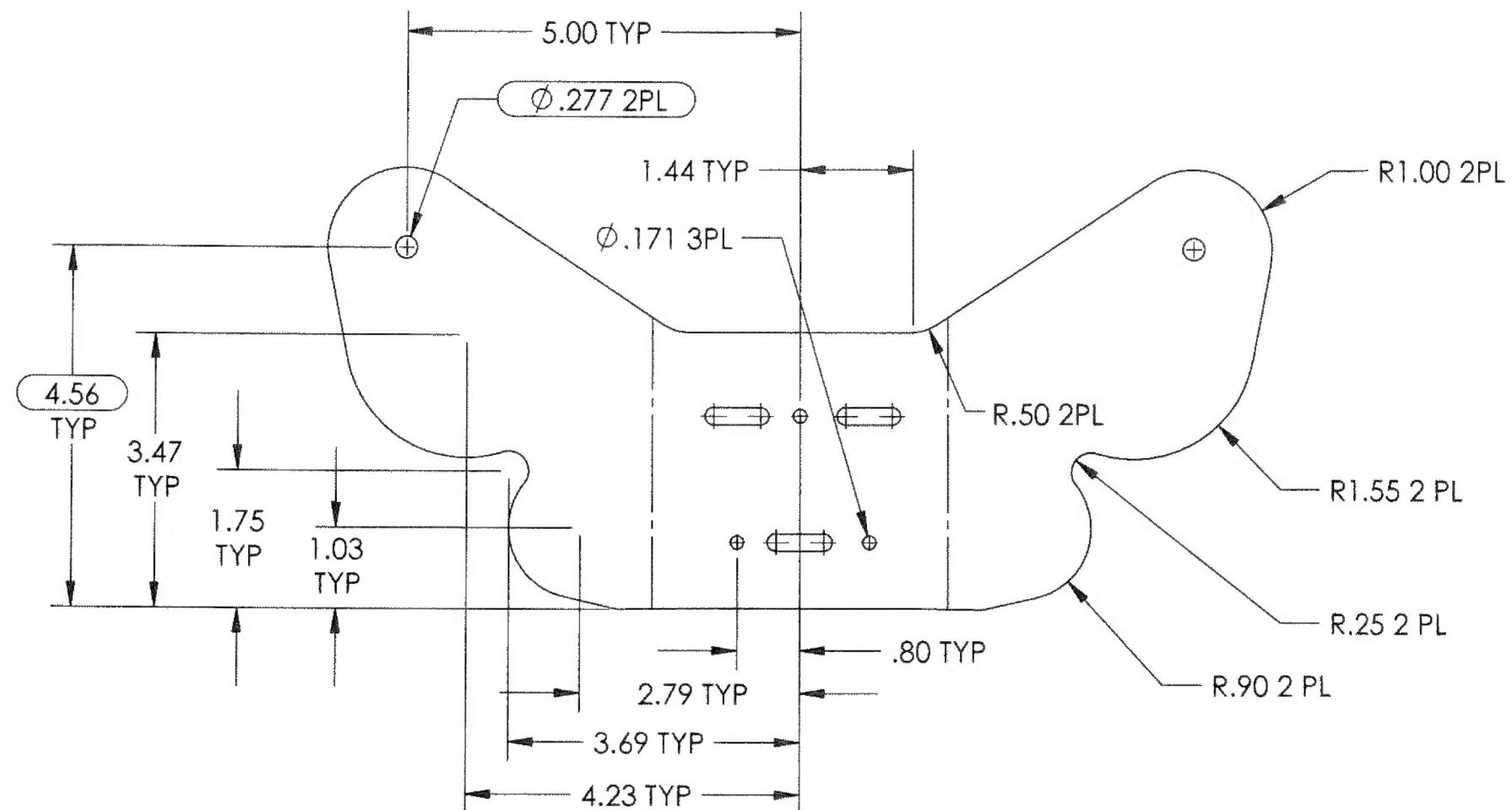
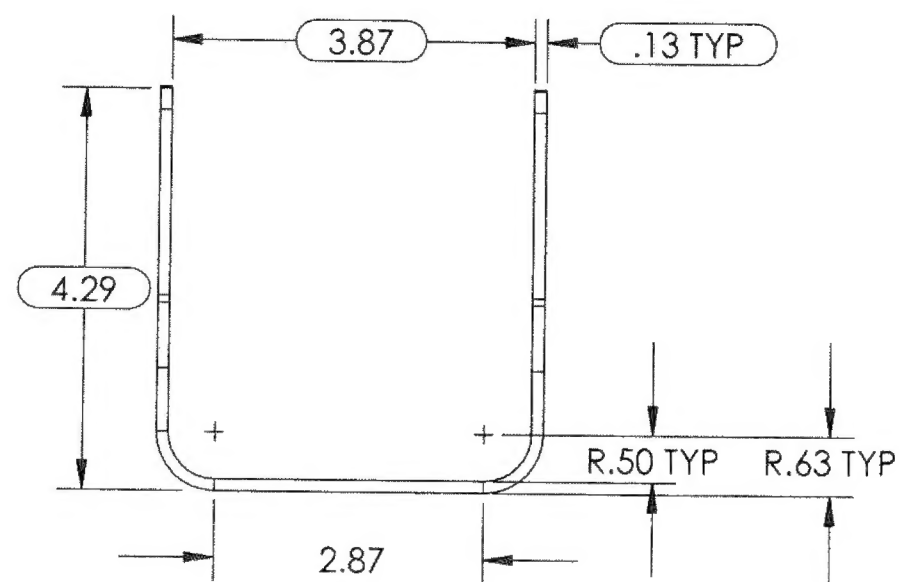
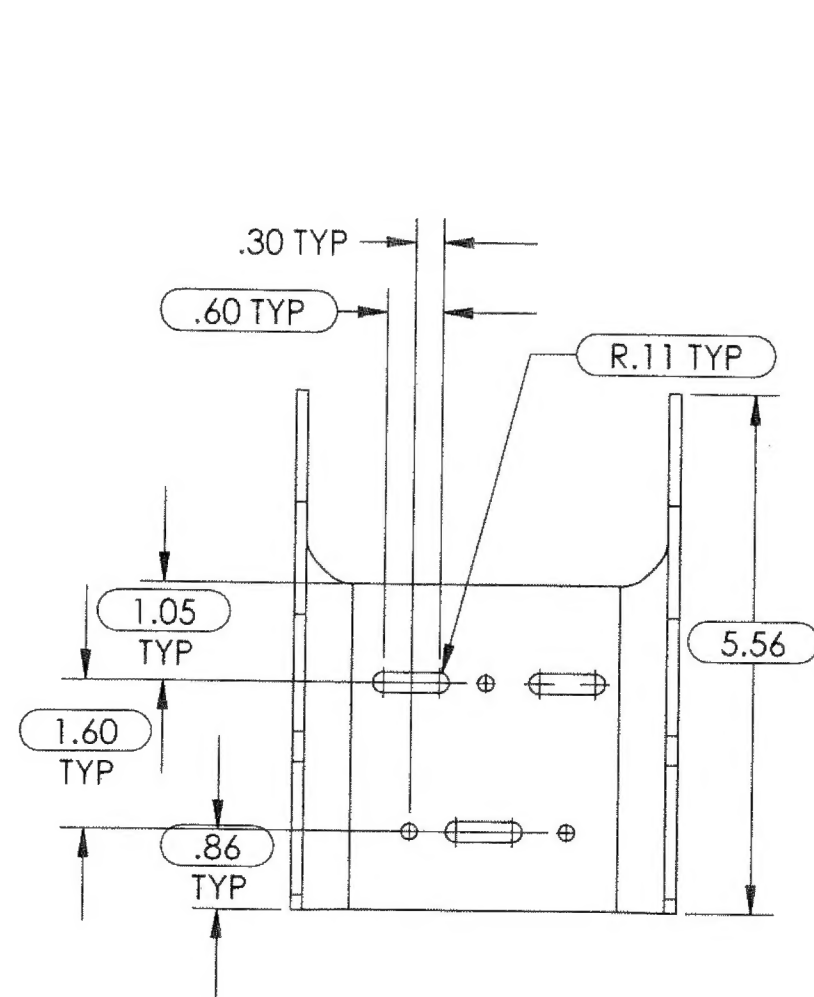
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644.4110  
BRACKET (LARGE), AFT

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D. PARROTT	CHECKER S. JOSEPH		
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SRE B	REV. F
		CAGE CODE 07MZ6	DWG. NO. 644.4100
		SCALE NONE	SHEET 2 OF 16

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644.4111  
BRACKET, AFT PIVOT

ORIGINAL DATE (MO-DAY-YR)	08-01-05	<h1 style="text-align: center;">APICAL INDUSTRIES</h1> <p style="text-align: center;">2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300</p>			
DRAWN BY D. PARROTT	CHECKER S. JOSEPH				
DRAWING APPROVAL S. JOSEPH 08-27-05		<h2 style="text-align: center;">PIVOT STEP ASSY</h2>			
CONTRACT NO.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SIZE	CAGE CODE	DWG. NO.	REV.
		B	07M26	644.4100	F
		SCALE NONE		SHEET	3 OF 14

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A

B

C

D

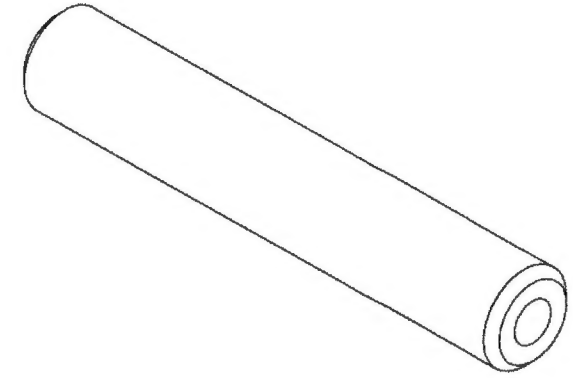
3.54  $\triangle 7$

$\phi .51$   
TYP

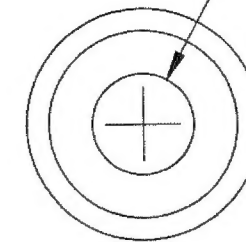
$\phi .63$

.06 X 45.0°

644.4112  
SPACER

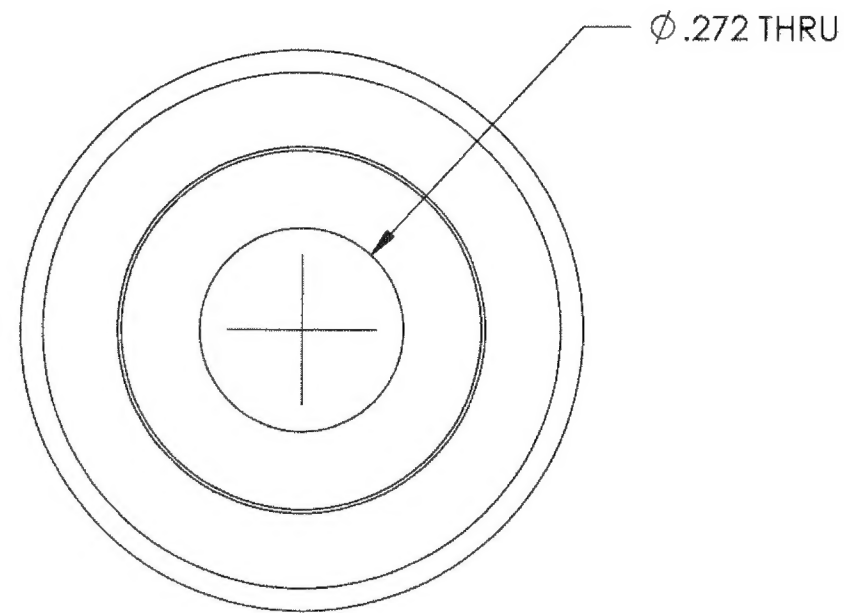
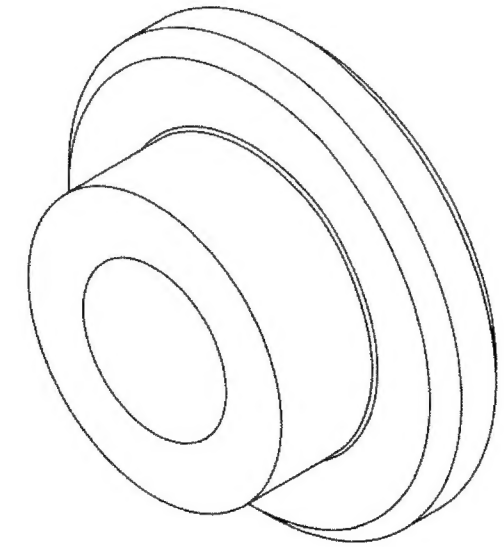
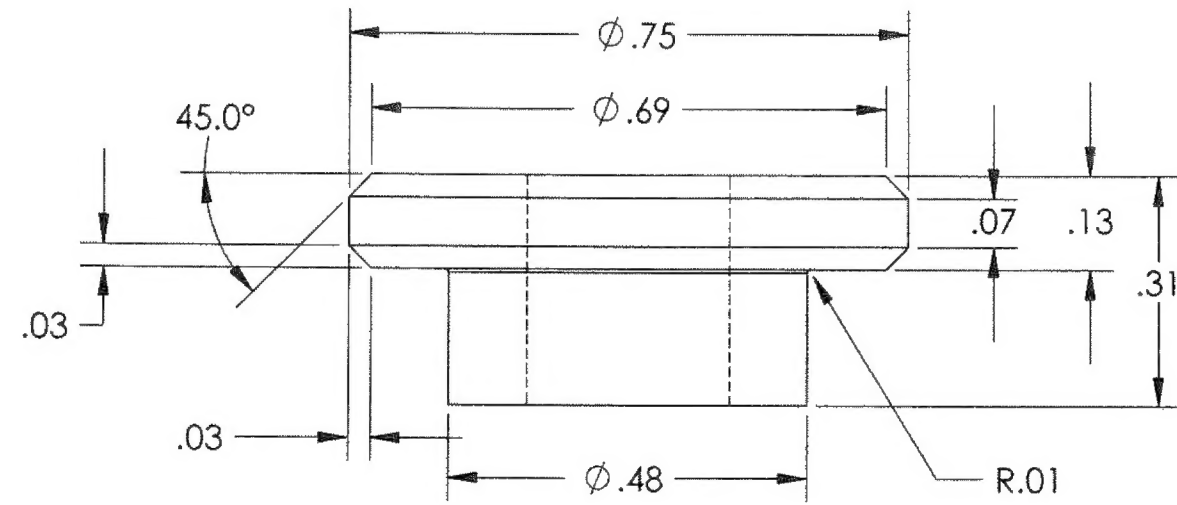


$\phi .272$  THRU



ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES		
DRAWN BY D. PARROTI	CHECKER S. JOSEPH	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY		
CONTRACT No.				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SRT B	CAGE CODE 07MZ6	DWG. NO. 644.4100
		SCALE NONE		REV. F
		SHEET 4 OF 16		

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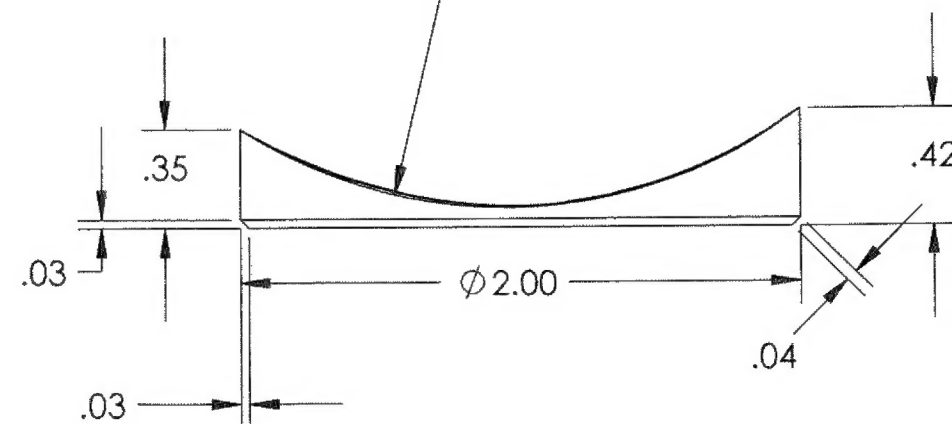
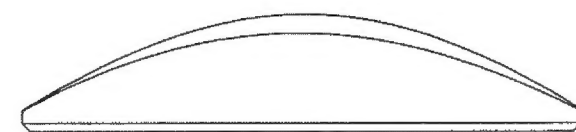


644.4113  
SPACER, STOP

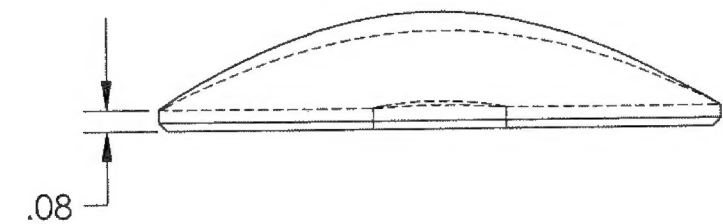
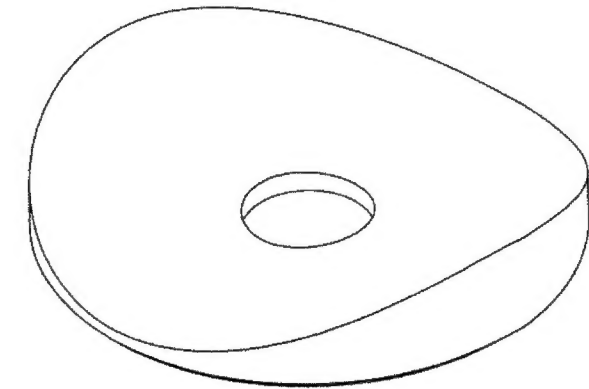
ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES	
DRAWN BY D. PARROTT		2608 TEMPLE HEIGHTS DR.	
CHECKER S. JOSEPH		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SIZE B	REV. F
SCALE NONE		CAGE CODE 07MZ6	DWG. NO. 644.4100
SHEET 5 OF 16			



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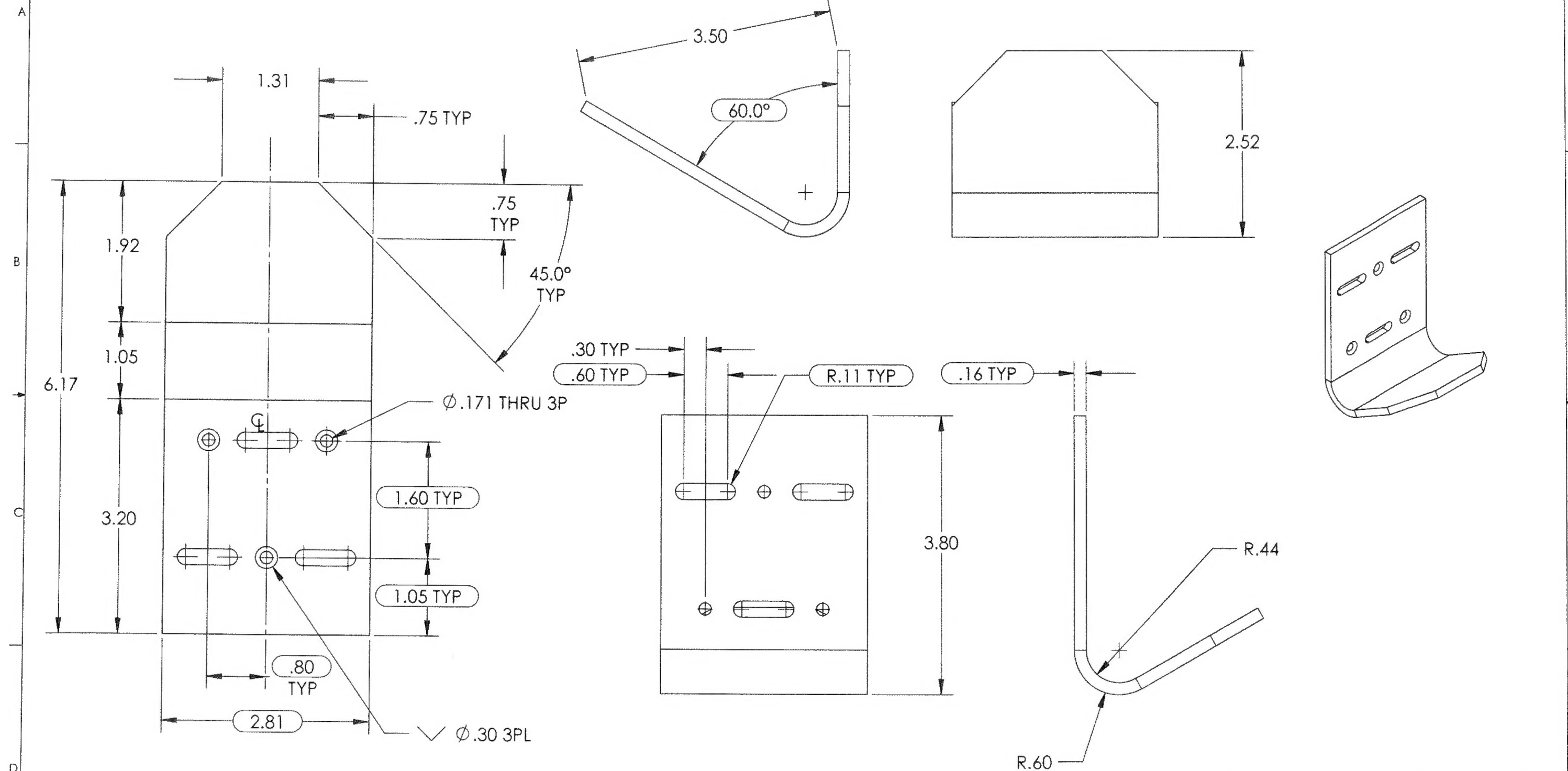
644.4114  
WASHER, PIVOT



ORIGINAL DATE 08-01-05 (MO-DA-YR)		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D. PARROTT	CHECKER S. JOSEPH		
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT No.		SIZE B	REV. F
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		DWG. NO. 07MZ6	644.4100
		SCALE NONE	SHEET 6 OF 16



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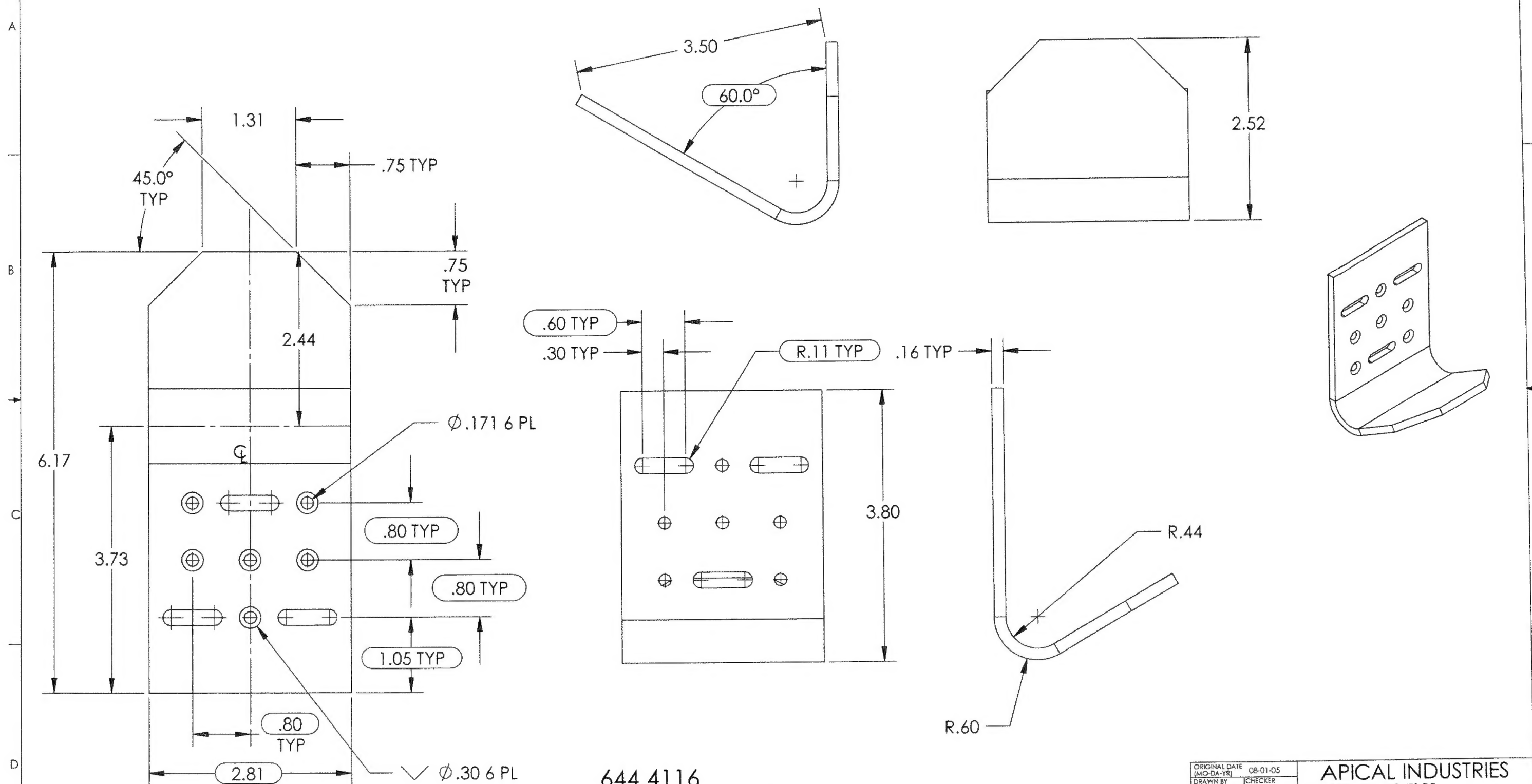


644.4115  
BRACKET (SMALL), AFT

FLAT VIEW

ORIGINAL DATE 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D. PARROTT	CHECKER S. JOSEPH		
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT NO.		SIZE B	REV. F
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		CAGE CODE 07M26	DWG. NO. 644.4100
SCALE NONE		SHEET 7 OF 16	

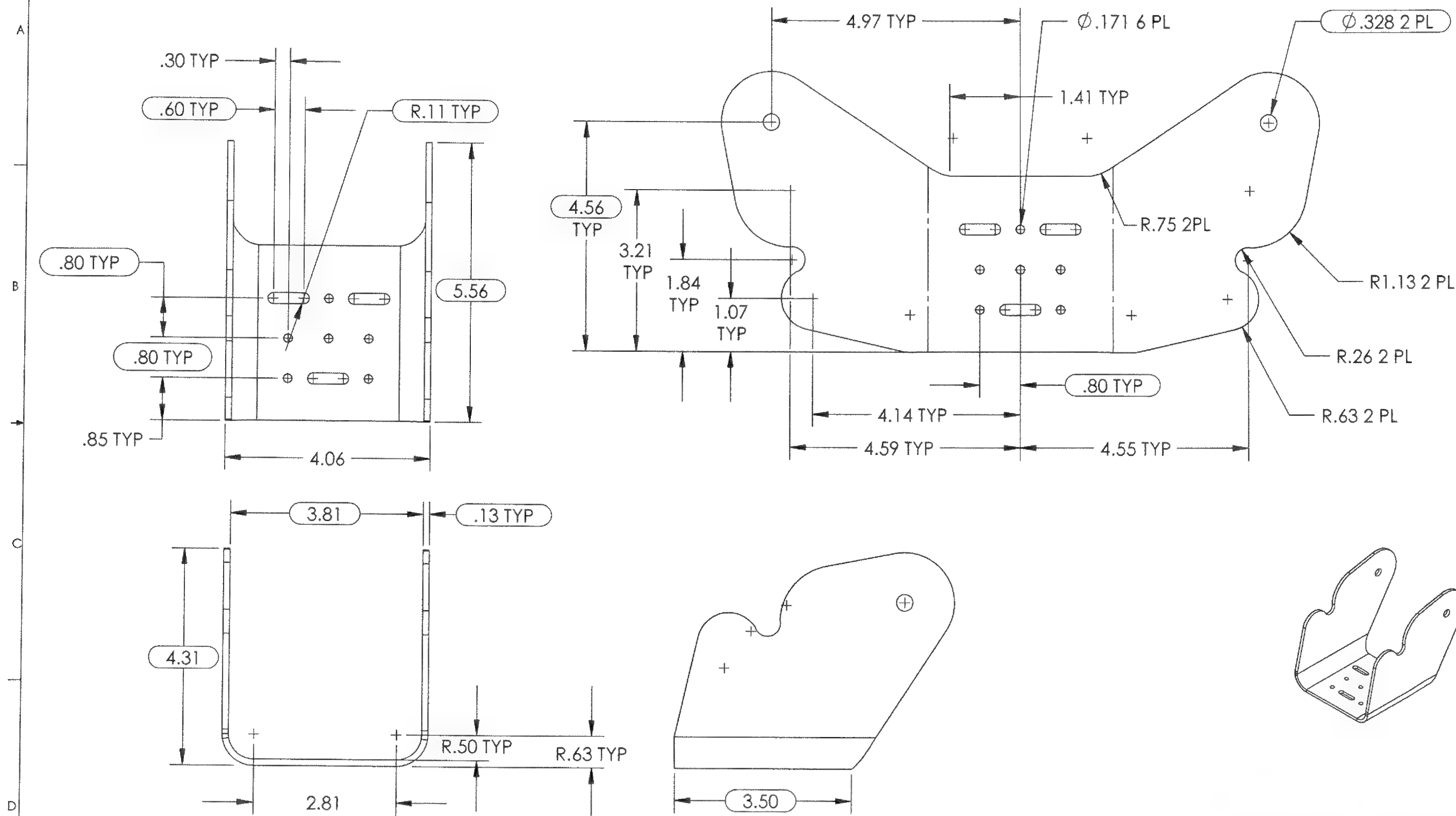
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644.4116  
BRACKET (SMALL), FWD

ORIGINAL DATE (MO-DA-YR)		08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY	CHECKER	D. PARROTT	S. JOSEPH		
DRAWING APPROVAL		S. JOSEPH	08-29-05		
CONTRACT No.				PIVOT STEP ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SHEET	CAGE CODE	DWG. NO.	REV.
		B	07MZ6	644.4100	F
		SCALE NONE		SHEET 8 OF 16	

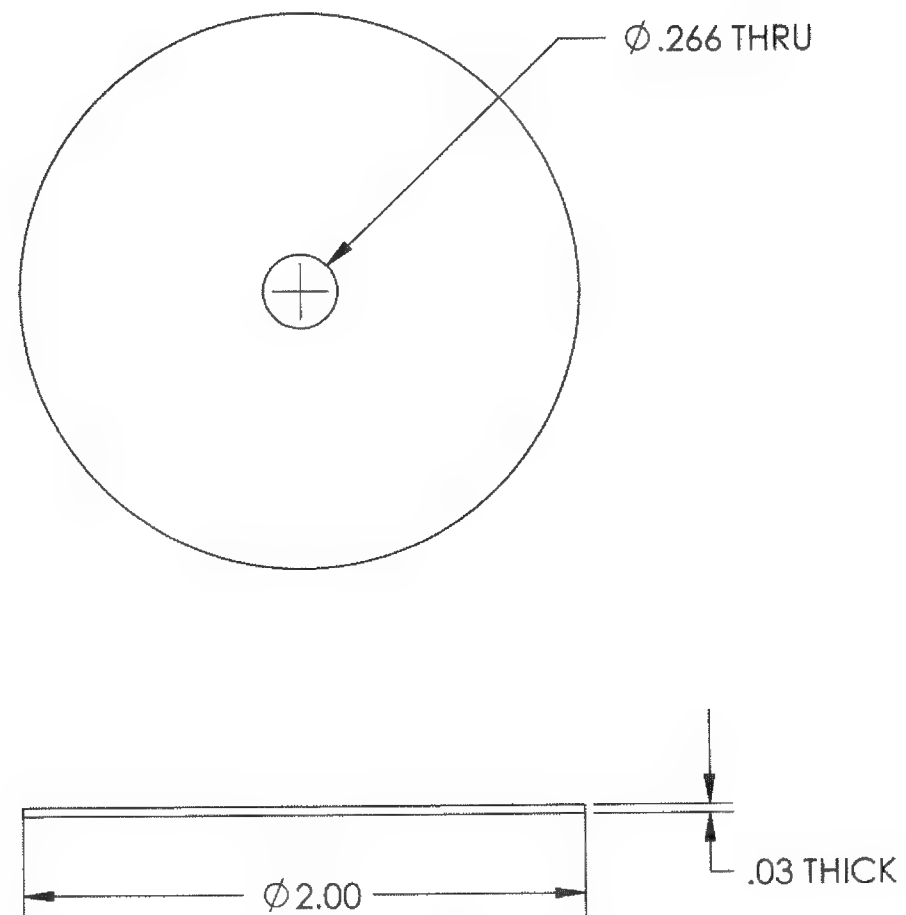
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644.4117  
BRACKET, FWD PIVOT

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES	
DRAWN BY D. PARROTT	CHECKER S. JOSEPH	2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL S. JOSEPH 08-29-05		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT No.		PIVOT STEP ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:		SIZE B	REV. F
2 PLACE DECIMALS $\pm .03$		CAGE CODE 07M26	DWG. NO. 644.4100
3 PLACE DECIMALS $\pm .010$		SCALE NONE	SHEET 9 OF 16
ANGLES $\pm .5^\circ$			

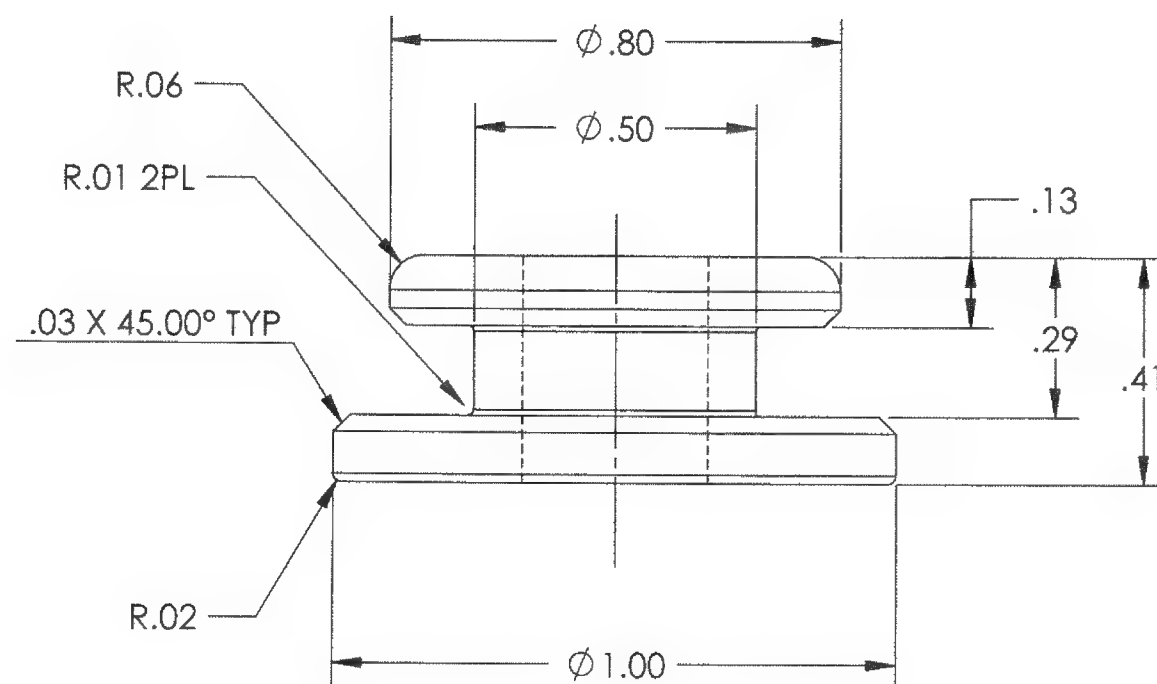
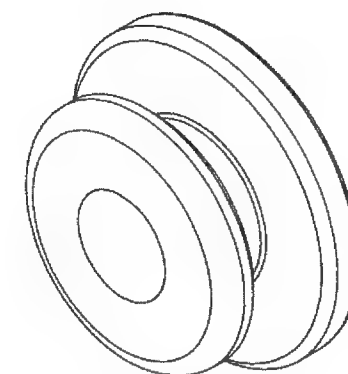
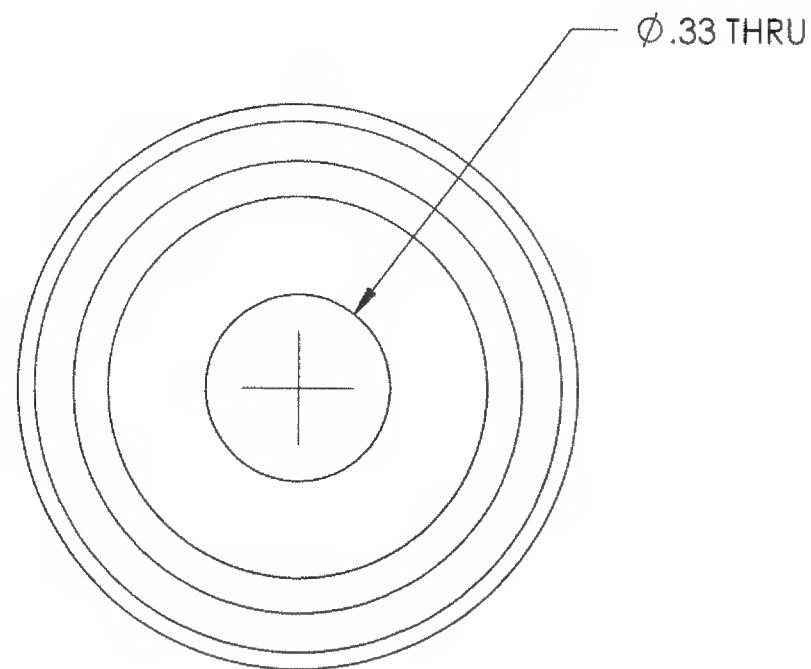
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644.4118  
WASHER, NYLON

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D.PARROTT	CHECKER S.JOSEPH		
DRAWING APPROVAL S.JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SHEET B	REF. F
CAGE CODE 07MZ6		DWG. NO. 644.4100	
SCALE NONE		SHEET 10 OF 16	

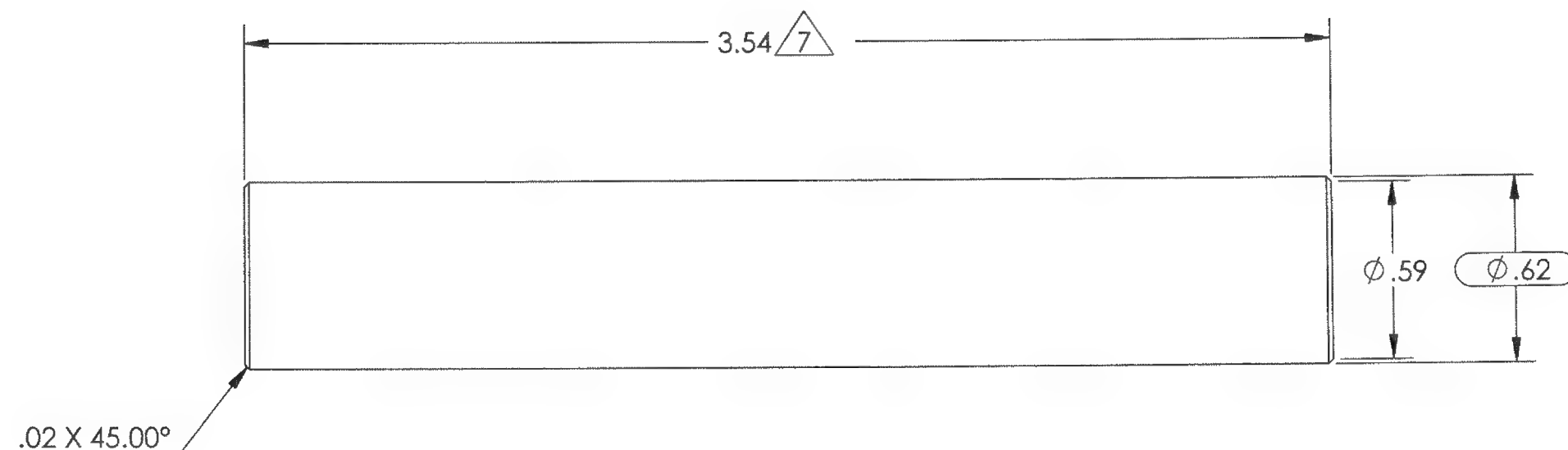
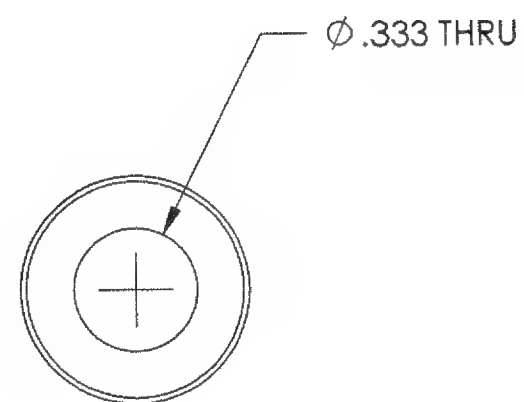
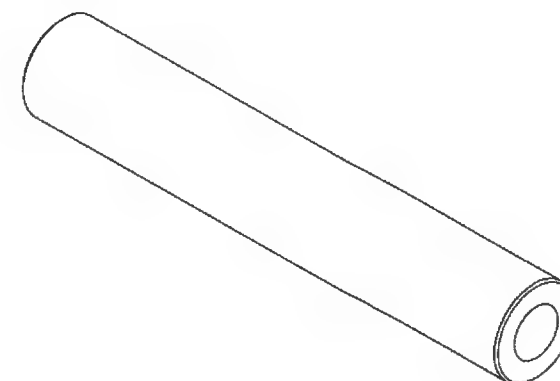
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644.4119  
SPACER, FWD STOP

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAWN BY D. PARROTT	CHECKER S. JOSEPH				
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY			
CONTRACT No.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SIZE B	CAGE CODE 07M26	DWG. NO. 644.4100	REV. F
		SCALE NONE			SHEET 11 OF 16

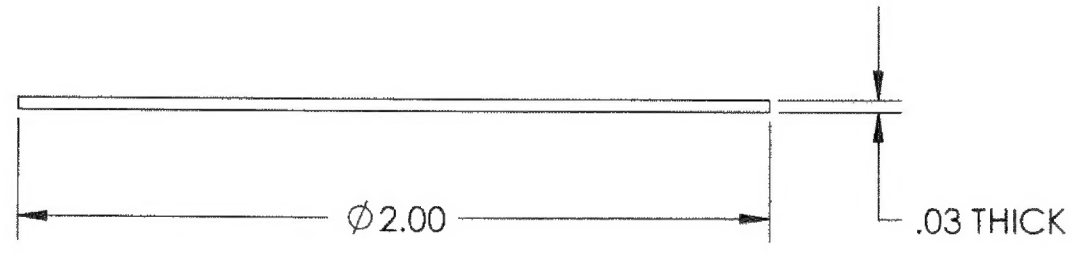
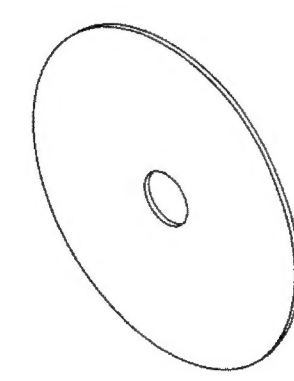
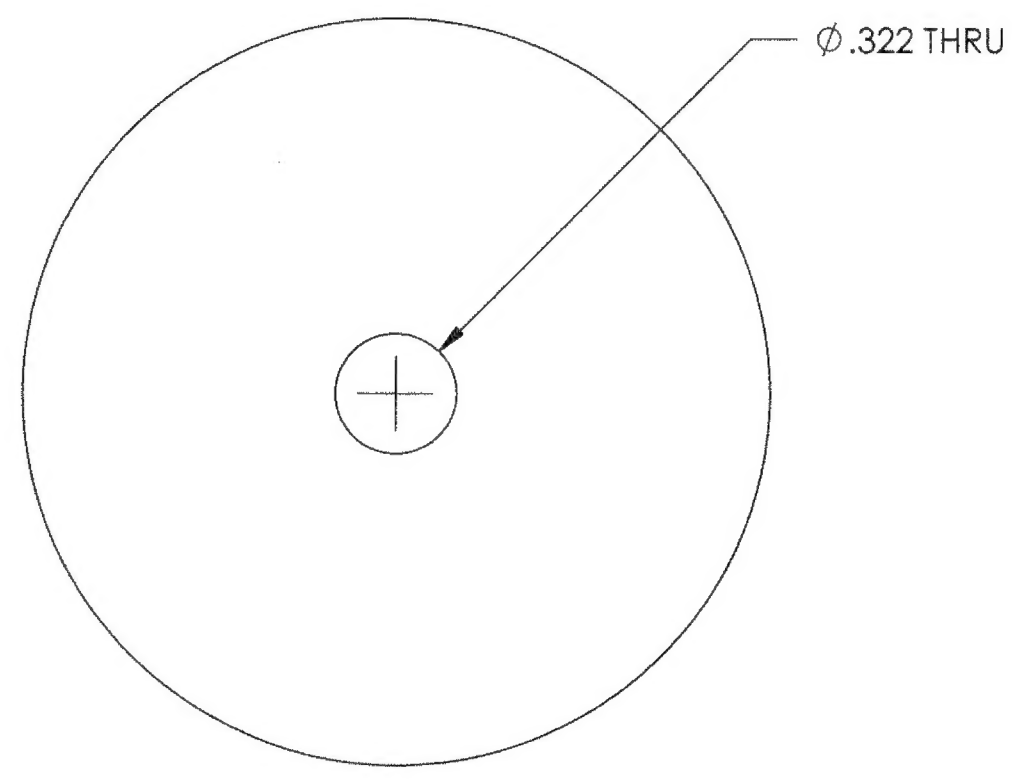
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644.4120  
SPACER, CROSS-TUBE

ORIGINAL DATE J-MO-DA-YR 08-01-05	APICAL INDUSTRIES		
DRAWN BY D. PARROTT	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		
CHECKER S. JOSEPH	PIVOT STEP ASSY		
DRAWING APPROVAL S. JOSEPH 08-29-05			
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ± .5°	SIZE B	CAGE CODE 07MZ6	DWG. NO. 644.4100
	SCALE NONE		REV. F
		SHEET 12	OF 16

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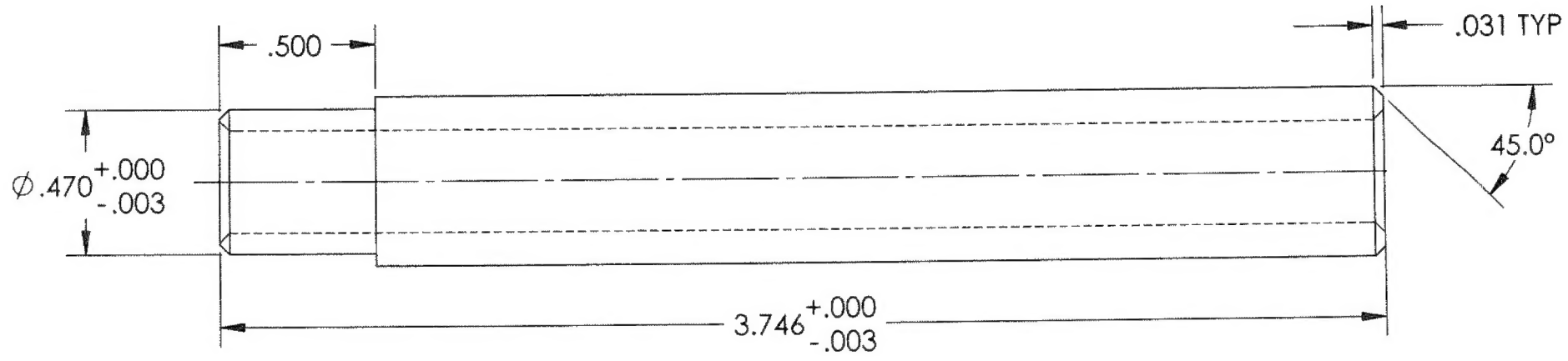
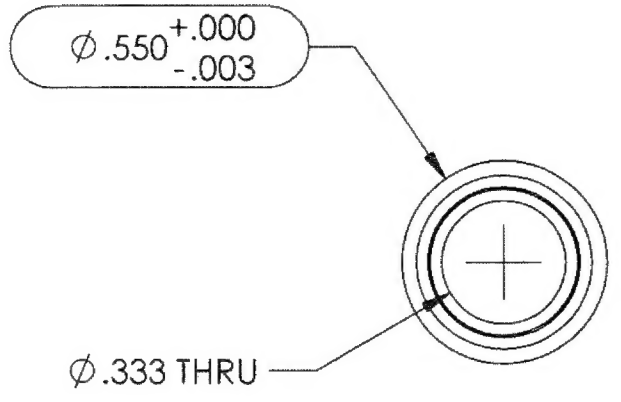


644.4121  
WASHER, NYLON

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAWN BY D.PARROTT	CHECKER S.JOSEPH				
DRAWING APPROVAL S.JOSEPH 08-29-05		PIVOT STEP ASSY			
CONTRACT No.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ± .5°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 644.4100	REV. F
		SCALE NONE		SHEET 13 OF 16	



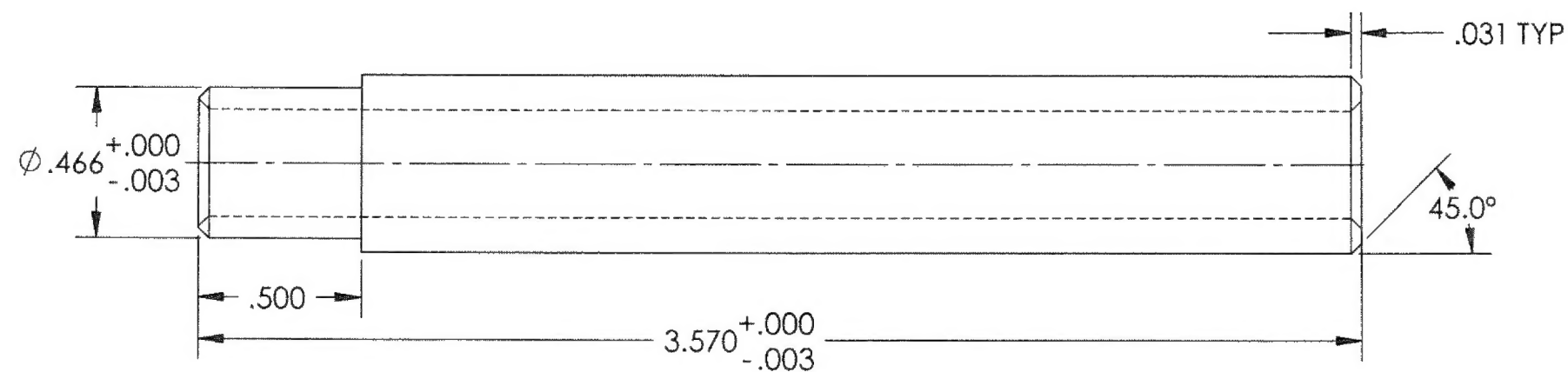
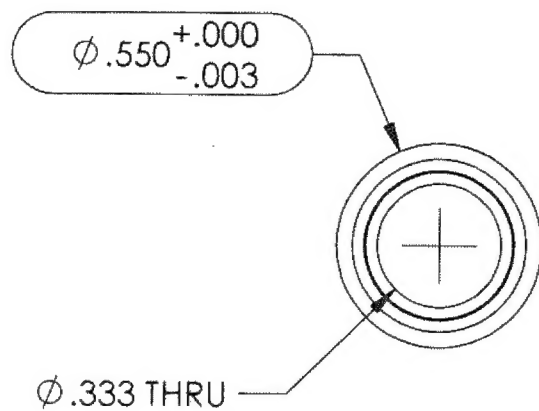
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644.4122

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CHECKER S. JOSEPH		PIVOT STEP ASSY	
DRAWING APPROVAL S. JOSEPH 08-29-05		DWG. NO. 644.4100	
CONTRACT No.		REV. F	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SIZE B	CAGE CODE 07MZ6
SCALE: NONE		SHEET 14 OF 16	

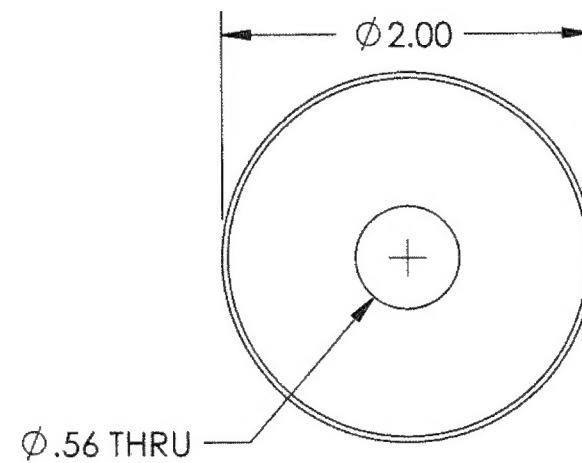
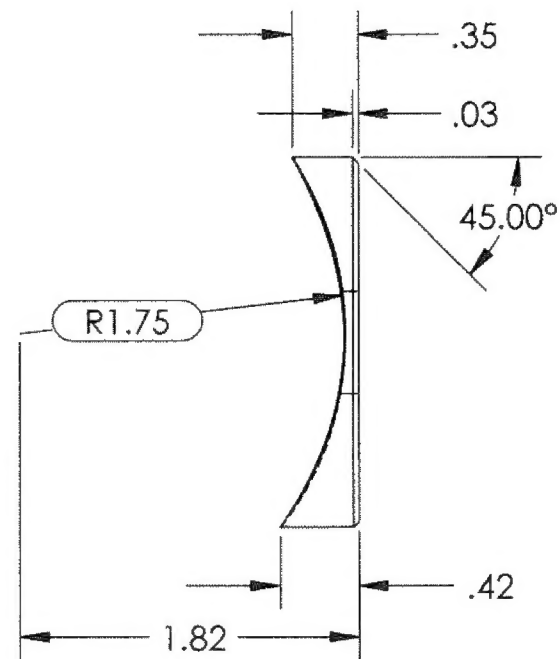
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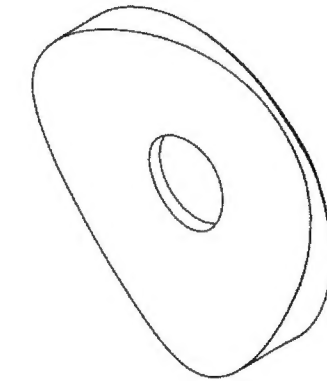
644.4123

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CONTRACT No.				
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		SHEET 15 OF 16		

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644.4124



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DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SIZE B	REV. F
		CAGE CODE 07M76	DWG. NO. 644.4100
		SCALE: NONE SHEET 16 OF 16	